

Date: Tuesday, 2/26/2008 8:01:51 AM
 User: Kim Johnston

Process Sheet

13

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	GHW MEDIUM BELL	
Job Number	37627A		Part Number	D412729041	
Estimate Number	12129		Drawing Number	DSK 092 REV B	
P.O. Number			Project Number	N/A	
This Issue	2/26/2008	S.O. No.	Drawing Revision	B	
Prsht Rev.	NC		Material		
First Issue	/ /	Type	MACHINED PARTS	Due Date	3/25/2008 Qty: 2 Um: Each
Previous Run	37051A				
Written By					
Checked & Approved By	<u>1080226</u>				
Comment	Est Rev.E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL If D412-729-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-729-041 CHG003	N/A <i>ky</i>
2.0	D27287	Decal	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D27287 Label <u>22554</u>	<i>AS 08/05/20 (X2)</i>
3.0	D3233041	Wheel Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-041 Wheel Assembly <u>B37638</u>	<i>CPL 08.05.28</i>
4.0	D32331	Inside Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-1 Inside Washer <u>B3763</u>	<i>AS 08/05/20 (X1)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #: Machine Or Operation:

Description :

5.0 D32333 Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3233-3 Outside Washer B37074

AS 08/05/20 (x2)

6.0 D33091 Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3309-1 Label B37078

AS 08/05/20 (x2)

7.0 D33093 Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3309-3 Label B36197

AS 08/05/20 (x2)

8.0 D3330041 Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3330-041 Frame Weldment B37690 ✓

AS 08-05-25

9.0 D3331041 Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3331-041 Handle Assembly B37082

AS 08/05/20 (x2)

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 D3332041 Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly

B36163

① 37784 * 54
8/5/21

AS 08/05/20 (X2)

11.0 D3332043 Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly

37059

① 37059
8/5/21

AS 08/05/20 (X2)

12.0 D33331 Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate

B31522

AS 08/05/20 (X2)

13.0 D33333 Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate

B37084

AS 08/05/20 (X2)

14.0 D33335 Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail

37085

AS 08/05/20 (X2)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 D33341 Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft

337785

AS 08/05/20 (x2)

16.0 D33351 Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring

25295

AS 08/05/20 (x2)

17.0 D33353 Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring

36702

AS 08/05/20 (x2)

18.0 D33361 Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack

30954 → 1
B35445 → 1

PP 08/05/28

19.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer

M10732

AS 08/05/20 (x2)

20.0 CP21 1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 CP21 1/8" Cotter Pin 2" long

16626

AS 08/05/20 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 37627A		Part Number: D412729041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
21.0	2 CP-21 1/8" Cotter Pin 2" long, Span HC12	1/4-20 UNC x 1" Hex Bolt  
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span	M16529 AS 08/05/20 (X2)
22.0	HC29	5/16-18 UNCx1.5 Hex Bolt  
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s) Pick: Qty Part Number Description Batch 16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof	106512 X3 M107524 X29 AS 08/05/20 (X2)
23.0	HC153	3/8"-24UNFx1.25 Hex Bolt  
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch 8 HC-153/8"-24 UNF x 1.25" long Hex Bolt, Span	M107031 AS 08/05/20 (X2)
24.0	HN120	HEX SLOTTED NUT  
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 HN-1201" Slotted Nut, Prof	102150 AS 08/05/20 (X2)
25.0	HN177	5/16-18UNC Nylon LockNut  
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s) Pick: Qty Part Number Description Batch 16 HN-1775/16"-18 UNC Nylon Lock Nut, Span	107031 AS 08/05/20 (X2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span 16626

AS 08/05/20 (x2)

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M107464

KS 08/05/20 (x2)

28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span 102150

AS 08/05/20 (x2)

29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB 3/8" Lock Washer, Span 167031

AS 08/05/20 (x2)

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span M180312

AS 08/05/20 (x2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 5/16"WC Type B Flat Washer (Narrow), Prof

M1d68.609

AS 08/05/20 (X)

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(P)08-05-28



(X2)

Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/29 (X2)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

1PP 3 7627

08/05/28 Tst

35.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

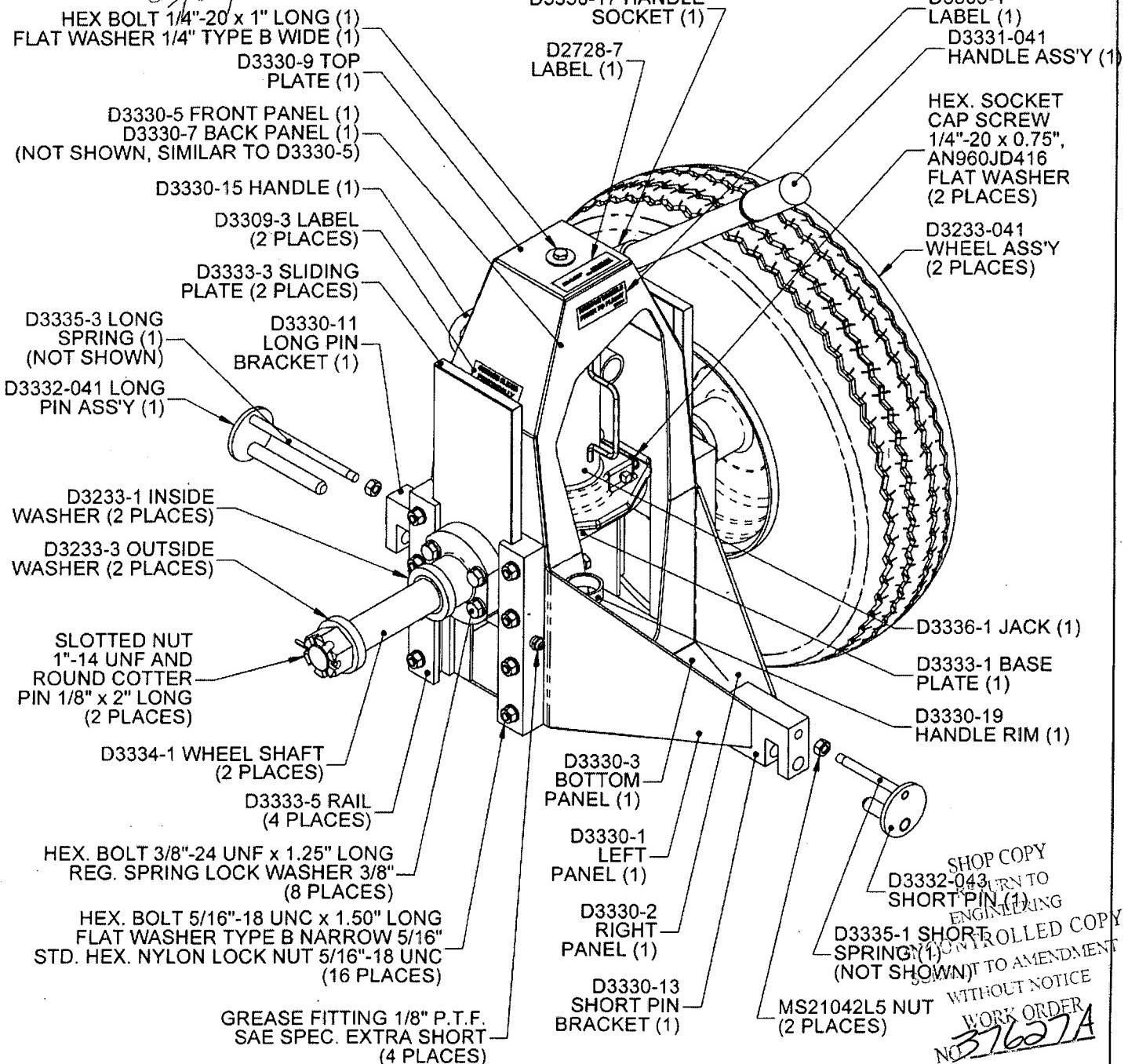
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NOTE: Date & initial all entries



DESIGN ✓	DRAWN BY JW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED MJS	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A 04.12.06	NEW ISSUE		
B 05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y		

RELEASED
05/02/18



NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.